

Work Order ID 81584

March-15-12 3:29:47 PM

Push 4 60 *81584*

Page 1

Item ID: D4021-9

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 3/15/12 Start Qty: 60.00

60

Cust Item ID:

Required Date: 3/16/12 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00

100

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA 868 AND DWG D4021

DWG REV: 3

FOLIO REV: AA

***MACHINE TO .375" MAX OD ***

DEBURR

60

Ø

rel 12/15/16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

60 Ø

rel 12/15/16

Work Order ID 81584

March-15-12 3:29:47 PM

81584

Page 2

Item ID: D4021-9

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 3/15/12 Start Qty: 60.00

60

Cust Item ID:

Required Date: 3/16/12 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

B.A 12/03/16

60

Quality Control

130

Identify as per dwg & Stock Location ST WA 0.00

130

Packaging

Memo

0.00

Packaging

60x SP 12-03-16

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/3/19

12-03-14

Picklist Print

March-15-12 3:29:47 PM

Page 1

Work Order ID: 81584
Parent Item: D4021-9
Parent Item Name: Bushing

Start Date: 3/15/12
Start Qty: 60.00

Required Date: 3/16/12
Required Qty: 60.00

Comments: IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD IPP Rev:B as per dwg REV.A
DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No				f	20.0310		4.98			
304 ROUND BAR 0.375													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT029	20.031	
119346	1.564	
120204	18.467	


4.98 12/15/16

81584

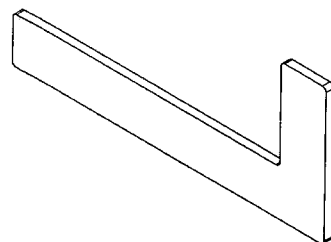
FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

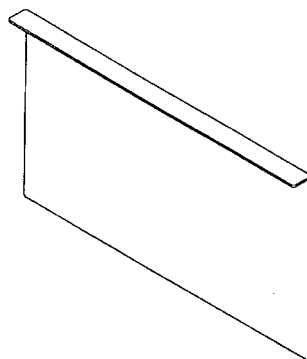
Measured by: <i>Y</i>	Audited by: <i>Da</i>	Preliminary Approval:
Date: <i>12/03/16</i>	Date: <i>12/03/16</i>	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	

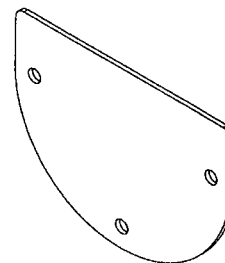
8 7 6 5 4 3 2 1



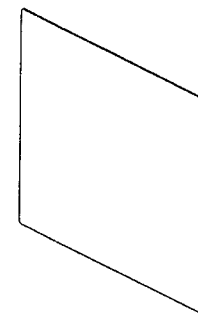
D4021-1 HANDLE PLATE



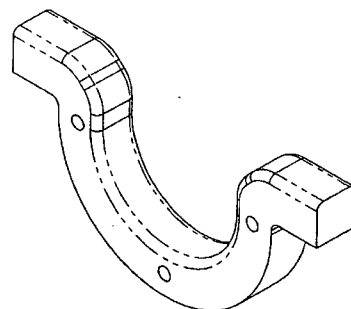
D4021-3 DATA PLATE



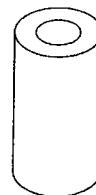
D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



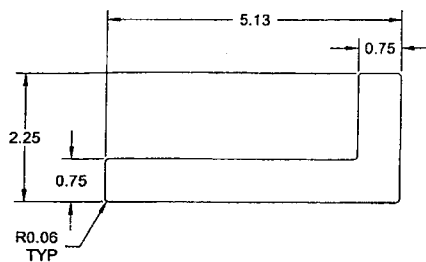
D4021-9 BUSHING

W/B 8/584

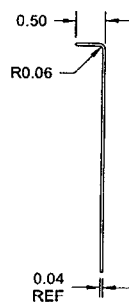
RELEASED
2010-04-14

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D4021	SHEET 1 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	MISC PARTS - 350 BASKET	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.04.06	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

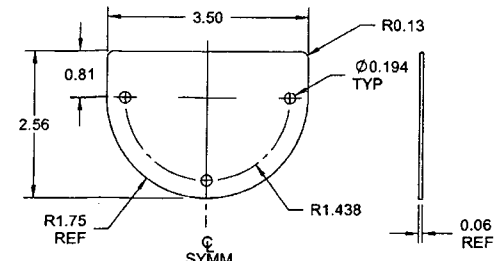
8 7 6 5 4 3 2 1



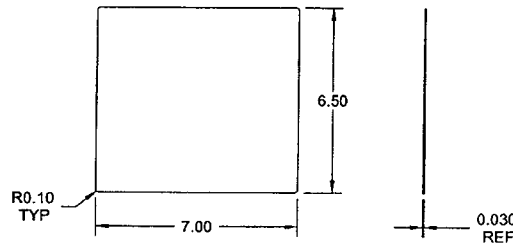
D4021-1 HANDLE PLATE



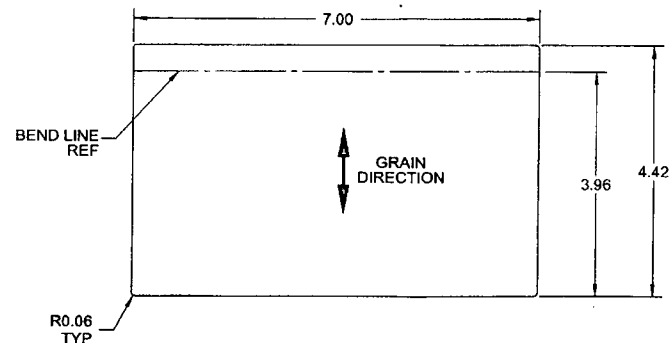
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE





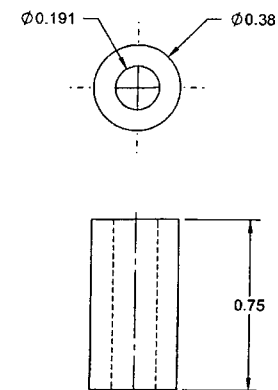
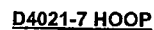
D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
R 2010-04-14
NM

- NOTES:**
- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
 - 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
 - 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
 - 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH:** -1/-3/-11: NONE
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES:** PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS:** INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES:** 0.005 TO 0.010 MAX
- 6) IDENTIFICATION:** N/A
- 7) WEIGHT:** -1: 0.18 lbs -3: 0.35 lbs
-5: 0.14 lbs -11: 0.39 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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D4021-9 BUSHING

1) MATERIAL-7: 304/316 STAINLESS STEEL BAR; PER ASTM A276
REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R

-9: 0.02 lbs

RELEASED
2010-04-14

NF

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DRAWN	JPH		SHEET 3 OF 3
CHECKED			
MFG. APPR.			
APPROVED			SCALE
DE APPR.			NTS
DATE	10.04.06		